



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2572
Job Sheet 184838



Part No: D2572

Job Qty: 12 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining		18/11/18 ↓
100	CNC Vertical Machining	12 pcs	11/9/18	11/9/18	0.62	19.35	HAAS 1		SBL 1/11/18
110	Mill Conv	12 pcs	11/9/18	11/9/18	0.00	2.00	Mill Conv 1		↓
120	QC	12 pcs	11/9/18	11/9/18	0.00	0.00	QC2		
130	QC	12 pcs	11/9/18	11/9/18	0.00	0.00	QC8		
140	HandFinish	12 pcs	11/9/18	11/9/18	0.00	0.49	HandFinish1		
150	Powdercoat	12 pcs	11/9/18	11/9/18	0.00	0.46	Powdercoat1		
160	QC	12 pcs	11/9/18	11/9/18	0.00	0.00	QC3		
170	Packaging	12 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3	5/317	
180	QC21-SA	12 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 100 - Program Batch No. S12438 Double check by: ML 1-Machine Step No 1 per Folio FA051 and inspect per Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp
110 - Machine keyway as per dwg D2571 & D2572
150 - START TIME: 8:05 FINISH TIME: 8:25 O.V.T. 320° M138951.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	12	30	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches	1.755		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S124386



Part: D2572

Job No: 184838

Serial No/Batch: S124386

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/04/18

FAULT CATEGORY

ect e/Unqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
ete/Unclear	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

			+ 0.010	1.745
			- 0.000	
5	Saddle, Fwd Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

DART AEROSPACE LTD	Work Order: 184838
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	8.000	8.00		
F	0.490	0.510		0.500	.494	.500	.497		
G	0.257	0.262		0.257	.257	.257	.257		
H	0.375	0.380		0.375	.375	.375	.375		
I	0.490	0.510		0.499	.500	.498	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5675	.567	.567	.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.875	3.875		
P	0.115	0.135		0.135	.130	.135	.135		
Q	0.115	0.135		0.131	.127	.127	.127		
R	0.240	0.260		0.259	.253	.253	.253		
S	0.115	0.135		0.130	.126	.127	.127		
T	0.178	0.198		0.188	.188	.188	.188		
U	2.940	2.980		2.964	2.960	2.960	2.960		
V	0.230	0.250		0.248	.245	.247	.247		
W	0.115	0.135		0.128	.130	.130	.128		
X	0.307	0.312		.311	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.363	.363	.363	.363		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.621	.623	.623	.622		
AC	0.053	0.073		0.070	.060	.057	.055		
AD	0.240	0.260		0.258	.256	.255	.255		
AE	1.375	1.395		1.364	1.385	1.385	1.385		
AF	0.115	0.135		0.135	.133	.135	.135		
AG	0.240	0.280		0.250	.250	.250	.250		
AH	0.240	0.260		0.250	.252	.252	.252		
AI	2.000	2.020		2.000	.200	.200	.200		
AJ	0.023	0.043		.030	.030	.033	.033		

Accept/Reject

Measured by: DAS
Date: 57 18/11/06
9.89

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

27

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DART AEROSPACE LTD	Work Order: 18488
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 1	6 2	7 3	8 4	By	Date
A	0.438	0.443	/	0.438	0.438	0.438	0.438		
B	1.745	1.755	/	1.750	1.750	1.750	1.750		
C	3.495	3.505	/	3.500	3.500	3.500	3.500		
D	1.745	1.755	/	1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	7.999	7.999		
F	0.490	0.510		0.497	0.497	0.496	0.500		
G	0.257	0.262	/	0.257	0.257	0.257	0.257		
H	0.375	0.380	/	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.498	0.498	0.498	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.565	0.566	0.567	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500	/	1.495	1.495	1.495	1.496		
N	2.495	2.505	/	2.500	2.500	2.500	2.500		
O	3.869	3.879	/	3.874	3.875	3.875	3.875		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.127	0.126	0.126	0.126		
R	0.240	0.260		0.252	0.252	0.251	0.251		
S	0.115	0.135		0.128	0.125	0.128	0.126		
T	0.178	0.198	/	0.188	0.188	0.188	0.188		
U	2.940	2.980	/	2.962	2.962	2.960	2.960		
V	0.230	0.250		0.240	0.248	0.247	0.246		
W	0.115	0.135		0.128	0.126	0.126	0.126		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.365	0.364	0.364		
AA	0.470	0.530	/	0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.622	0.623	0.622		
AC	0.053	0.073		0.055	0.055	0.053	0.055		
AD	0.240	0.260		0.250	0.257	0.257	0.257		
AE	1.375	1.395	/	1.385	1.385	1.385	1.385		
AF	0.115	0.135	/	0.125	0.125	0.125	0.125		
AG	0.240	0.280	/	0.250	0.250	0.250	0.250		
AH	0.240	0.260	/	0.255	0.255	0.255	0.255		
AI	2.000	2.020	/	2.000	2.000	2.000	2.000		
AJ	0.023	0.043	/	0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	DAS
Date:	57 9-89

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 184838
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	11 3	12 4	By	Date
A	0.438	0.443 ✓		0.438	0.438	0.438	0.438		
B	1.745	1.755 ✓		1.750	1.750	1.750	1.750		
C	3.495	3.505 ✓		3.500	3.500	3.500	3.500		
D	1.745	1.755 ✓		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	7.999	7.999		
F	0.490	0.510		0.498	0.499	0.500	0.499		
G	0.257	0.262 ✓		0.257	0.257	0.257	0.257		
H	0.375	0.380 ✓		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.4975	0.500	0.501	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.566	0.566	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500 ✓		1.495	1.495	1.500	1.500		
N	2.495	2.505 ✓		2.500	2.500	2.500	2.500		
O	3.869	3.879 ✓		3.874	3.874	3.875	3.875		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.252	0.252	0.253	0.253		
S	0.115	0.135		0.130	0.133	0.131	0.130		
T	0.178	0.198 ✓		0.188	0.188	0.188	0.188		
U	2.940	2.980 ✓		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.249	0.249	0.248	0.247		
W	0.115	0.135		0.126	0.125	0.124	0.123		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765 ✓		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.363	0.363		
AA	0.470	0.530 ✓		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.623	0.624	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.259	0.259	0.259	0.259		
AE	1.375	1.395 ✓		1.385	1.385	1.385	1.385		
AF	0.115	0.135 ✓		0.135	0.135	0.135	0.135		
AG	0.240	0.280 ✓		0.250	0.250	0.250	0.250		
AH	0.240	0.260 ✓		0.250	0.250	0.250	0.250		
AI	2.000	2.020 ✓		2.000	2.000	2.000	2.000		
AJ	0.023	0.043 ✓		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: DAS
Date: 57
9-89

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

